

5/04

SPLIT


<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	22032 A
<b>Description:</b> Fuel Purge Canister	<b>Part Number:</b>	D3262-041
<b>Dwg:</b> D3262 Rev. A	<b>Qty:</b>	2 12
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler <b>Note: (1) D3262-041 consists of (1) D3262-1; (2) D3262-3</b>	HA	04.12.08	12
2	MV	<b>Cut (2) blanks per (1) D3262-041</b> Cut blanks: 6.000" x 0.500" x 5.400" long Bar Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick (M6061T6B0.500x06.000) <b>Identify for D3262-3</b> Batch: M11708	En	04/12/15	10
3	MV	Machine as per Folio FA457 and Dwg D3262 <b>Identify as D3262-3</b>	En	05/01/04	10
4	QC2	Inspect parts as they come off the CNC machine	En	05/01/04	10
5	QC8	Second check	En	05.01.12	10
6	MV	Deburr	En	05/01/04	10
7	MV	Cut D3262-1 to length as per Dwg D3262 Material: 6061-T6 (QQ-A-200/8 or 225/8) 5.00 OD x 0.125" wall (M6061T6T5.000W.125) <b>Identify as D3262-1</b> Batch: M15362	SD	05.01.12	4
8	WA	Weld canister assembly as per Dwg D3262 using DT8739 to align fillings <b>Pick:</b> Qty Part Number Description Batch A/R Aluminum Rod M15855	SE	05/02/22	2
9	QC5	Inspect work to Step 8	AB	05.01.12	2
10	PG	Issue P/O: For Liquid Penetrant inspection as per Dwg D3262, QSI 038 & as per ASTM E1417 Level 1 Possible Supplier: NDT <b>Copy of NDT results is required.</b>			
11	RG	Receive and Inspect for transit damage <b>Ensure copy of NDT results are attached.</b>			
12	QC6	Inspect for damage and ensure results are as per Dwg D3262 <i>Pressure: 2 to 10 psi and submerge under water to check for leaks.</i>	AB	05.02.22	2
13	FP	Chemical Conversion Coat as per QSI 005 4.1	ML	05.02.22	2
14	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3 <b>Ensure to mask threads</b>	ML	05.03.03	2
15	QC3	Inspect Powder Coat	CL	05/03/04	2
16	ST	Identify with Dart part number and batch number using a fine point permanent ink marker, then Stock	CL	05/03/04	2
17	AC	Cost / part: 101.86 325181	Syc	05.03.08	2
18	DC	Close W/O 101.86 Inspect Level 21	HA	05.03.10	2

Rev	Date	Change	Revised By	Approved
A	04.09.02	New issue	KJ/JLM	
B	04.09.29	Added Steps 10-12; changed Step 16	KJ/JLM	

RELEASED

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector
02.05.22	10 & 11 12	CHANGE PROCEDURE AS PER DWG D3262 REV. B.	<i>[Signature]</i>			<i>[Signature]</i> 05.02.22	<i>[Signature]</i> 05.03.22

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Initial	Corrective Action Section B	Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
05-01-11	3	10 parts scrap 9/16-18 UNF holes were tapped crooked operator error  holes	<i>[Signature]</i> 05-01-11	Identify pieces as scrap and use for test welding operator retrained	<i>[Signature]</i> 05-01-12	<i>[Signature]</i> 05-01-12	<i>[Signature]</i> 05/01/12	<i>[Signature]</i> 05-01-12

PAR#: N/AFault Category: N/ADQA: *[Signature]*Date: 05/03/10

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order:	22032
Description: Cap		Part Number:	D3262-3
Inspection Dwg: D3262	Rev: <del>A</del> B A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070 x 45°	+/-0.010	0.070x45° ✓	✓		vern	
0.45	+/-0.030	0.456 -	-		mic	
R0.06	+/-0.030	0.060 -	-		R.G	
0.080	+/-0.010	0.076 -	-		vern	
0.33	+/-0.030	0.327 ✓	✓		Depth mic	
5.030	+/-0.010					cannot find dim
4.125	+/-0.010					cannot find dim
2.375	+/-0.010					cannot find dim
0.688	+0.005/-0.000	0.688 -	-		vern	
3.250	+/-0.005	3.248 -	-		vern	
Ø5.030	+0.010/-0.000	5.030 -	-		vern	
Ø0.875	+0.005/-0.000	0.875 -	-		vern	
Ø0.516	+0.005/-0.000	0.516 -	-		vern	
Ø5.190	+0.005/-0.000	5.190 -	-		vern	
0.83	+0.015/-0.000	0.83 -	-		Depth mic	
Ø0.580	+0.015/-0.000	0.580 -	-		vern	

Measured by: <i>Ep</i>	Audited by:	Prototype Approval:	N/A
Date: 04/12/20	Date:	Date:	N/A

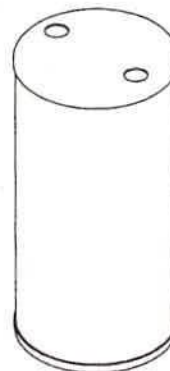
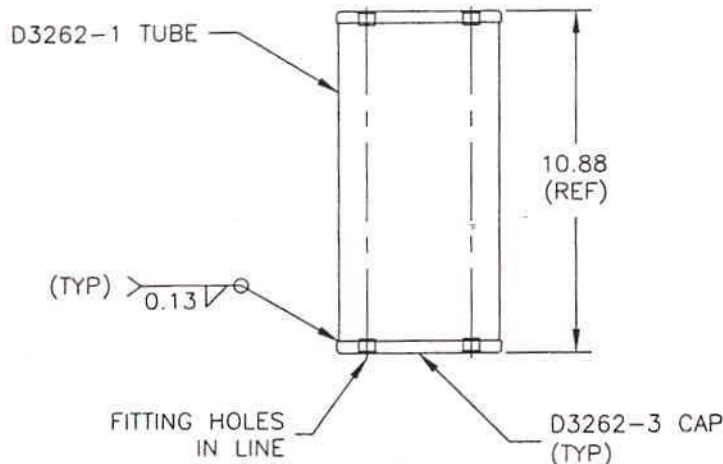
Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	P/O D3262-041	KJ/JLM

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04/09/03

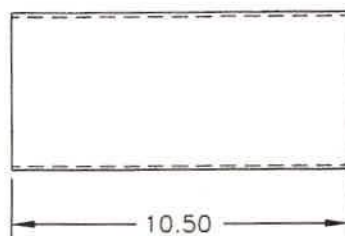


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3262	REV. A SHEET 1 OF 2
DATE 04.05.06		TITLE FUEL PURGE CANISTER	SCALE 1:1
A	04.05.06	NEW ISSUE	

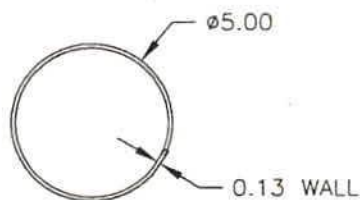
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04-07-09 #



### D3262-041 CANISTER ASSEMBLY



### D3262-1 TUBE



#### D3262-041:

- 1) MATERIAL: 6061-T6 (WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8)  
TUBING 5.00 OD x 0.125 WALL (6061T6T5.000W.125)
- 2) WELD PER QSI 004.
- 3) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

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FOR NOTICE  
WORK ORDER  
NO. 22032

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Technical drawing of a mechanical part, likely a bracket or support, showing dimensions and features. The part has a central horizontal section with a circular hole. Dimensions include overall width  $0.688 +0.015/-0.000$ , hole diameter  $0.580 +0.005/-0.000$ , and hole offset  $0.070 \times 45^\circ$  CHAMFER. Other dimensions include  $0.33$ ,  $0.45$ ,  $0.080$ ,  $0.875$  (REF), and  $R0.063$  (TYP). A feature is labeled "SEE DETAIL B".

Technical drawing of a mechanical part, showing a front view (left) and a cross-sectional view (right).

**Front View (Left):**

- Overall diameter:  $\phi 5.030^{+0.010}_{0.000}$
- Central slot width: 1.62
- Distance from center to side hole center: 3.25 (REF)
- Side hole diameter:  $\phi 0.875$
- Central hole diameter:  $\phi 0.516$  (REF)
- Bottom hole diameter:  $\phi 5.190$  (REF)
- Feature 7 (Surface Finish Symbol)
- Feature 2 (Surface Finish Symbol)
- Section line A-A

**Cross-sectional View (Right):**

- Top radius:  $R0.02^{+0.020}_{0.000}$
- Bottom radius:  $R0.02^{+0.000}_{-0.010}$
- Top fillet radius:  $0.083^{+0.015}_{0.000}$
- Angles:  $30^\circ$  and  $45^\circ$
- Section line A-A

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04-07-04 #

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR  
(REF. DART SPEC. M6061T6B)
- 2) TAP HOLE 9/16-18 UNF-3B PER MIL-S-8879
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP  
(MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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